

# Work Order ID 68831



Page 1

Thursday, April 21, 2011 11:33:46 AM

Item ID: D4070-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 4/21/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*CL*

Date: 11/04/21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4070

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg  
Prog rev: 1  
dwg rev: 1

*B 11-4-25*



110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

*B 11-4-25*

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

*5/10/25*

*counter*  
*(x26)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68831**

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Thursday, April 21, 2011 11:33:46 AM

Item ID: D4070-041

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Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 4/21/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	Form as per dwg  Memo	0.00  0.00		SB 11/04/26		26			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		Sub 11/04/26		26			
150  Small Fab Small Fab	Assemble rubber cushion as per dwg  Memo	0.00  0.00		SB 11/04/26		26			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 68831

Thursday, April 21, 2011 11:33:46 AM



Page 3

Item ID: D4070-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Clamp					
Start Date: 4/21/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 4/26/2011	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				<i>into</i> <i>x26</i>			
170  Packaging Packaging	ID $\frac{1}{2}$ Stock.  Memo	0.00 0.00		51 460				11/4/27	<i>SP (26)</i>
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00						11/4/28	<i>MF</i> <i>11-04-28</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 11:33:42 AM

Page 1

Work Order ID: 68831

Parent Item: D4070-041

Parent Item Name: Clamp



Start Date: 4/21/2011

Required Date: 4/26/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev A 10.02.16 new issue EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2182B		Manufactured	No				f	339.9836		1.894737			
Rubber Cushion													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST410	339.98357	
66063	339.98357	

Cut qty 1 at 1.80" long

M304S16GA

Purchased

No

100

sf

186.5000

0.019

0.24

1.



304/316 Sheet .063

1811-4-21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	186.5	
117275	186.5	

117275

26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 68831
<b>Description:</b> Clamp		<b>Part Number:</b> D4070-1
<b>Inspection Dwg:</b> D4070	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

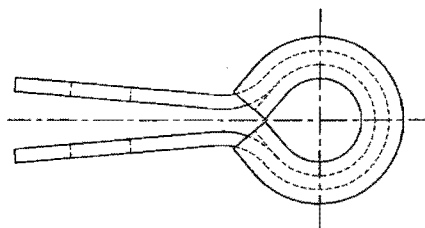
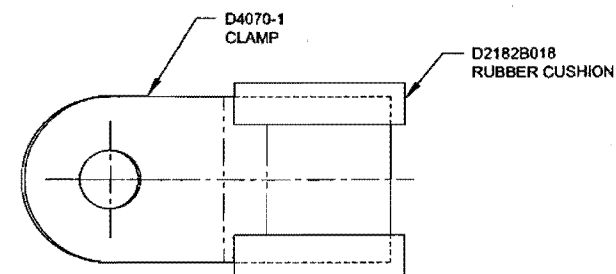
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266	+0.006/-0.001	.267	✓		✓ 12.02	
0.375	+/-0.010	.375	✓		✓	
0.750	+/-0.010	.753	✓		✓	
0.375	+/-0.010	.375	✓		✓	
2.903	+/-0.010	2.901	✓		✓	
3.653	+/-0.010	3.656	✓		✓	
0.063	+/-0.010	.060	✗		✓	

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-4-25	<b>Date:</b> 11/04/25	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.18	New Issue	KJ	AS



QTY	PART NUMBER	DESCRIPTION
X	D4070-041	CLAMP
1	D4070-1	CLAMP
1	D2182B018	RUBBER CUSHION



**D4070-041 CLAMP**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4070-041" USING REMOVABLE TAG
- 7) WEIGHT: 0.05 lbs

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68831  
2/11/04/21

**RELEASED**  
2010-02-16  
WTP

A	NEW ISSUE	CP	10.02.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.12		

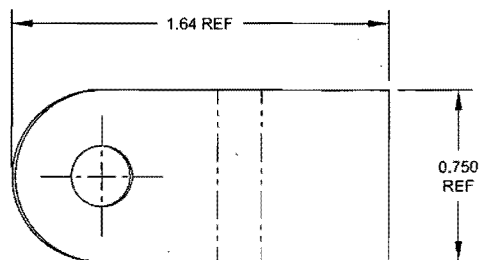
  

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4070	REV. A
TITLE CLAMP	SCALE NTS
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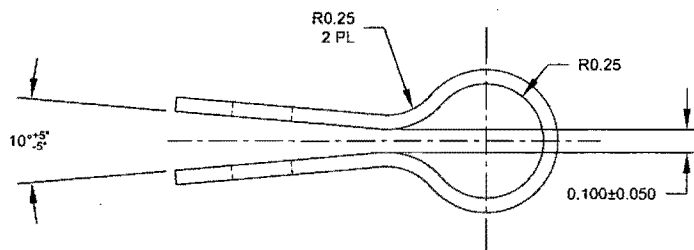


8 7 6 5 4 3 2 1

D



C



B

**D4070-1 CLAMP**  
(MAKE FROM D4070-1F)

**NOTES:**

- 1) MATERIAL: MAKE FROM D4070-1F
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

A

8 7 6 5 4 3 2 1

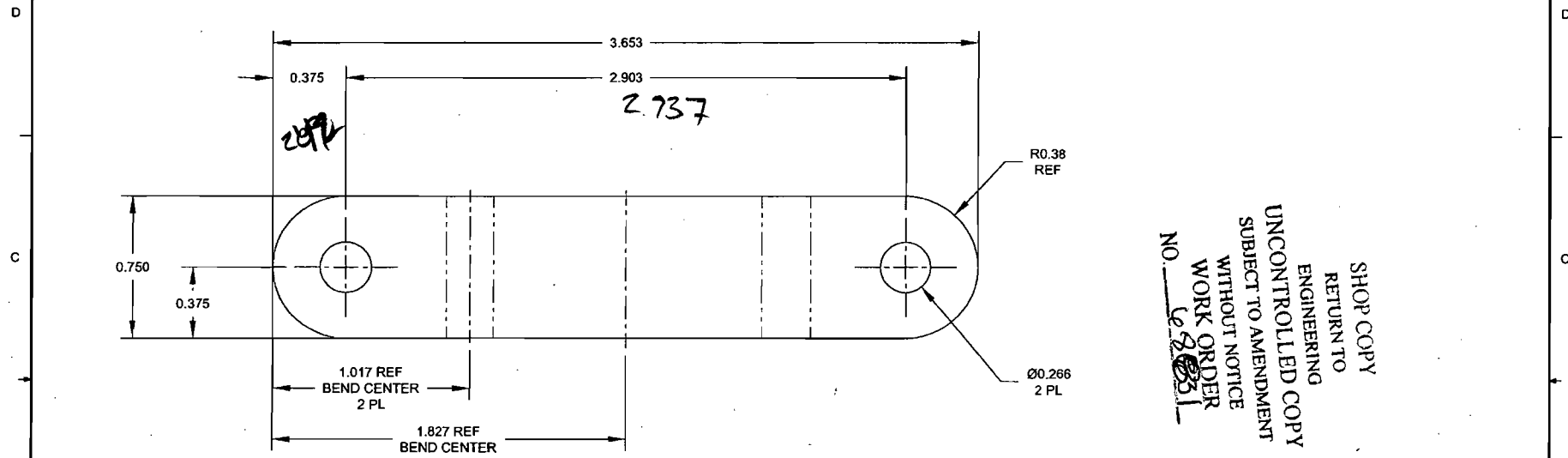
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MD

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8 7 6 5 4 3 2 1



**D4070-1F FLAT PATTERN**

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68051

**RELEASE**  
2010-02-16

**NOTES:**

- 1) MATERIAL: AISI 304/316 SHEET 16 GAUGE (0.063 THICK)  
ANNEALED, 2B FINISH  
PER MIL-S-5059 OR AMS 5513 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4070	SHEET 3 OF 3
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8 7 6 5 4 3 2 1

